

shopbce.com



Work. Learn. Earn.

BUREAU OF CORRECTIONAL ENTERPRISES

OUTREACH



ABOUT US

BCE has 16 teams, with workers from 11 correctional facilities, providing opportunities for those workers to receive vocational training and develop work skills. BCE sells a variety of products and services to federal, state, and local government agencies, and non-profit organizations.

Wisconsin statutes dictate that BCE be a profitable enterprise. BCE profits are used to: pay BCE employees and workers; buy raw materials to manufacture products; purchase, repair and replace equipment; fund BCE's Transition program; and develop additional opportunities.

The work BCE and its customers do together contribute to a safer Wisconsin by enabling persons in our care to achieve greater success. This includes success with employment and not returning to DOC custody. This reduction in the number of persons in DOC care helps the department avoid some costs.

BCE is proud to offer high-quality products and services at competitive prices, and to contribute to a better Wisconsin.

“We make many things, we make furniture, road signs, license plates, clothing, mattresses, pillows, we have a herd of about 1,100 cattle, but each of those is a secondary product, our primary product is Opportunity.”

Wes Ray | BCE Director



2	ABOUT US A FEW WORDS ABOUT BCE
4	WORD FROM OUR DIRECTOR A LETTER FROM THE BCE DIRECTOR
5	A LETTER FROM THE SECRETARY A LETTER FROM THE WI DOC SECRETARY
6	OUR SALES / OUR MILESTONES FACTS AND NUMBERS YOU SHOULD KNOW
8	OUR BCE LOCATIONS A MAP OF OUR LOCATIONS
10	AGRICULTURE ALL ABOUT BCE AGRICULTURE
12	INDUSTRIES ALL ABOUT BCE INDUSTRIES
18	LOGISTICS ALL ABOUT BCE LOGISTICS
20	TRANSITION ALL ABOUT BCE TRANSITION
22	MAKING A DIFFERENCE / IMPACTING LIVES BCE AND OUR IMPACTFULNESS

TABLE OF CONTENTS

WORD FROM OUR DIRECTOR

Two BCE teams developed new products to help customers respond to COVID-19. BCE Textiles developed cloth face masks in accordance with CDC recommendations, and produced more than 28,000 in the first 30 days. BCE cloth masks continue meeting customer needs for washable, high-quality, two-ply cotton masks. BCE Custom Signs developed Safe Space Products by BCE. Printing and Signs Superintendent Mark Hennessy led our Custom Signs team in the design and production of stickers, signs and clear barriers customers use to support healthy workplaces. I applaud these examples of the creative work done by the employees and workers on BCE teams.

BCE continues its outreach efforts to customers and employers by telling and reminding them what BCE is, what BCE does and how Wisconsin wins the more they and BCE work together. Talks with customers also focus on the products and services they can buy from BCE. Talks with employers also include information about how BCE Transition can help them meet some of their staffing challenges by connecting them with former BCE workers who are local, skilled and experienced. Our Bureau is funded by sales revenue, so customer outreach is critical to meeting our mission. Our Bureau helps DOC more fully meet its mission by contributing to workers' employment success.



I will take this opportunity to bring our focus onto Fiscal Year 2020-21 (FY21). Our Product Development Center (PDC) has been key to the design, support and promotion of BCE products and the Bureau overall. Product design work focused on updates to BCE's Marathon deskling products. Product support work focused on furniture price lists used by our furniture sales team in their work with customers. Promotional work focused on sales brochures, BCE's outreach magazine and the design of www.shopbce.com, BCE's new website. Employees and workers on this team partner with the Department's Bureau of Technology Management to use NetSuite to improve our Internet presence and make our website www.shopBCE.com a shopping destination for BCE customers.

The Bureau's teams of employees and workers will continue in FY21 to strengthen our organization, operations and financial viability. Look forward to focused efforts on marketing and sales in our furniture, sign and printing industries. Also expect information about BCE's outreach to inform employers about our Bureau and its interest in helping them meet their staffing challenges.

Sincerely,

Wes Ray, BCE Director
Bureau of Correctional Enterprises

A LETTER FROM THE SECRETARY OF THE DOC

The work of the Wisconsin Department of Corrections' Bureau of Correctional Enterprises (BCE) may never have been as vital to our state as it is at this moment in history.

The various recruitment and "Help Wanted" signs seen in cities and towns across Wisconsin are an easily-viable indicator of the worker shortages in our state, and many others. While Wisconsin's unemployment rate has dropped to a level we saw before the COVID-19 pandemic, worker vacancies keep rising in various industries in serious need of skilled workers.

The Bureau of Correctional Enterprises (BCE) helps justice-involved people learn the skills needed to help Wisconsin employers, in the current economy or any other. BCE helps its workers learn both technical skills and soft skills, connect with employers and identify community resources that will help them successfully transition back into the community.

I've always been a proponent of investing in people, all of whom have the capacity for positive change. Governor Evers and this administration continue to make an unprecedented investment in reentry and employment programs that supports those in our care as they prepare for a successful return to their homes. BCE plays a critical role in this work, ensuring its workers are able to financially contribute to their families and communities, post-incarceration. In addition, now more than ever, BCE workers are a skilled resource for Wisconsin businesses.

At the Wisconsin DOC, we believe "every person, every family and every community matters." Those in our care are no less valuable because of what they did in the past, and the skills they learn working with BCE ensure they will be valued in the future. I am proud to continue supporting BCE's mission and the workers on those teams. I encourage each of you to read this magazine to see the tremendous impact BCE is having on persons in our care and Wisconsin's workforce.

Thank you,

Kevin A. Carr, DOC Secretary
Wisconsin Department of Corrections



OUR SALES



BCE had \$28.7 Million in Sales

BCE sells to government and non-profit customers. Last year our sales were more than \$28.7 million to many satisfied customers across Wisconsin and the United States.



Only \$50,000 was Appropriated to BCE

We pride ourselves at BCE on managing our expenses well. For all BCE operations only \$50,000 of Wisconsin tax payer dollars were appropriated in FY21.



BCE Paid it's Workers \$721,430 in FY21

BCE understands the financial obligations our workers are accountable for. In FY21 we paid our workers \$721,430 increasing their ability to pay their financial obligations.



Our Vision

The Bureau of Correctional Enterprises makes a demonstrable contribution to public safety through our valued staff. We provide training and work experience for persons in our care that leads to long term success while in prison and in the community upon re-entry. Together we provide high quality products and services to our customers.

OUR MILESTONES



On Average 379 Workers are Learning

BCE employees works on 16 teams across the state. On an average workday, 379 workers are learning work skills at real jobs.



BCE Workers Clocked 655,000 Hours of Work

We provide a stable income for workers on our teams, and pride ourselves in offering as much work time as we are able. During FY21, BCE workers were able to get 650,000 hours to earn and learn.



88% of Former BCE Workers Earned Jobs

We view it as our responsibility to our BCE workers that they learn valuable job skills while employed. The numbers support our view as 88% of former BCE workers have earned jobs within 3 years of returning to their families and communities.



Our Mission

The mission of the Bureau of Correctional Enterprises is to enhance public safety by providing jobs and training for inmates which develop marketable skills and experience for inmates that leads to long term success while in prison and in the community upon re-entry. Together we provide high quality products and services to our customers.

OUR BCE LOCATIONS

BCE has 16 teams, with workers from 11 correctional facilities throughout the state of Wisconsin. Our agriculture operations are comprised of farm and dairy operations at three sites in Wisconsin. Badger State Logistics and our Industries Distribution Center both function out of Waupun, WI. Our Transition Program operates out of BCE's central office in Madison.



Agriculture

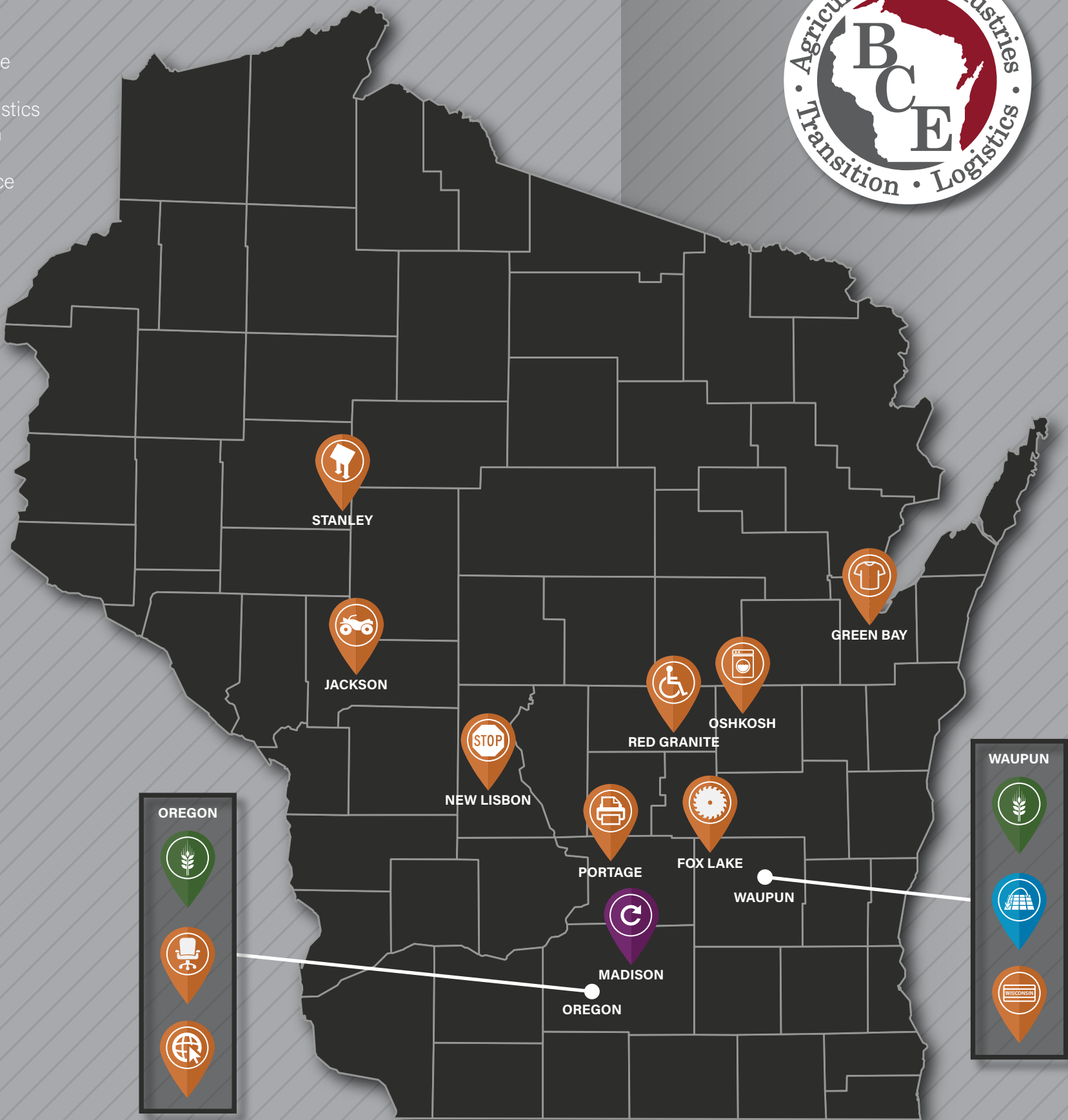
- WAUPUN & FOX LAKE FARMS**
 - Dairy Cows, Crops
- WAUPUN DAIRY**
 - Milk, Ice cream, and Sherbet
- OREGON FARM**
 - Dairy Cows, Crops

Logistics

- BADGER STATE LOGISTICS**
 - Commodities Warehouse
- INDUSTRIES DISTRIBUTION CENTER**
 - Transportation, Storage, Delivery & Installation
 - Computer Recycling

Transition

- TRANSITION PROGRAM**
 - BCE Central Office



Industries

- LAUNDRY & LINEN RENTALS**
 - Oshkosh Correctional Institution
- TEXTILES & EMBROIDERY**
 - Green Bay Correctional Institution
- METAL FABRICATION & STAMPING**
 - Waupun Correctional Institution
- PRODUCT DEVELOPMENT CENTER**
 - Oakhill Correctional Institution
- UPHOLSTERY**
 - Oakhill Correctional Institution
- PRINTING**
 - Columbia Correctional Institution
- WOOD FABRICATION**
 - Fox Lake Correctional Institution
- SIGN HYDRO-STRIPPING**
 - New Lisbon Correctional Institution
- ROAD & TRAIL SIGNS**
 - Jackson Correctional Institution
- DURABLE MEDICAL EQUIP. REFURBISHING**
 - Red Granite Correctional Institution
- CUSTOM SIGNS**
 - Stanley Correctional Institution



AGRICULTURE

Oregon Farm

This farm consists of approximately 530 acres. The primary crops are alfalfa, corn, soybeans, and wheat. These crops are grown primarily for herd consumption. It has a Holstein dairy herd of 180 milk cows and 170 replacement heifers. This team employs persons from Oakhill Correctional Institution.

Waupun & Fox Lake Farms

These farms consist of approximately 1,650 acres. The primary crops are alfalfa, corn, soybeans, and wheat. These crops are grown primarily for herd consumption. It has a Holstein dairy herd of 470 milk cows and 390 replacement heifers. This team employs persons from the John Burke Correctional Center.

Waupun Dairy

This dairy produces milk in 5 gallon and half pint containers as well as ice cream and sherbet in individual serving containers. The dairy also sells the cream available as a by-product from the production of the 1% milk it sells to customers. This team employs persons from the John Burke Correctional Center.



INDUSTRIES

Wood Fabrication

BCE Wood Fabrication is a manufacturing team that provides high-quality wood products with a focus on furniture. Those products include, but are not limited to, desks, tables, bookcases, files, and credenzas. This team uses manual and CNC (computer numeric control) equipment, along with modern CAD (computer aided design) software for greater flexibility in our design and production efforts. This team employs persons from Fox Lake Correctional Institution.

Upholstery

BCE Upholstery team provides professional, high-quality upholstered products for use in offices, dorms, lounges, and a variety of open seating areas. Upholstered furniture is offered with a large variety of fabric choices which include many colors, styles, patterns, and textures, as well as moisture barriers and self-sanitizing materials. The team also provides re-upholstery services and employs persons at Oakhill Correctional Institution.

Metal Stamping

Since 1921, BCE Metal Stamping has produced license plates for the State of Wisconsin. This team makes license plates for cars, trucks, motorcycles, and trailers used for both personal and commercial vehicles. The license plate products include 70+ specialty plates (including personalized) and 10+ cycle plates. The team also produces 15+ hand-screened license plates for Native American tribes. This team employs persons at Waupun Correctional Institution.

Metal Fabrication

BCE Metal Fabrication is an industry that sells metal products such as file cabinets, shelves, sit-stands, and monitor arms. This team currently does not fabricate or assemble any products, but sources products from vendors to meet customers' needs.

INDUSTRIES

Custom Signs

BCE Custom Signs produces traffic, street and trail, architectural and informational signs, banners, name badges, and name plates. The team uses modern materials, equipment and digital design, photography and silkscreen methods. Painted surfaces, heat-activated and pressure sensitive reflective sheeting materials are utilized in the production of signs. Signs are fabricated in various sizes, shapes, colors and textures. This team employs persons at Stanley Correctional Institution.

Road and Trail Signs

BCE Road and Trail Signs produces signs for use on interstate, state and local roads, and trails used for snowmobiles, ATV's, UTV's, bicycles, and hiking. Those signs are made on new and recycled aluminum blanks provided by BCE's Sign Hydrostripping team. This team employs persons at Jackson Correctional Institution.

Sign Hydrostripping

BCE Sign Hydrostripping produces new sign blanks and promotes environmental stewardship. Hydrostripping transforms outdated and weathered aluminum signs that no longer meet reflectivity standards into clean, reusable sign blanks. The hydrostripper applies high-pressure water to strip vinyl sheeting off decommissioned signs so the aluminum blank can be used again. The stripped blanks are then re-sheeted to make new signs. With our 100% Green Hydrostripping technology, the entire process is done without damaging the environment. This team employs persons at New Lisbon Correctional Institution.

Printing

BCE Printing products and services include typesetting, graphic design, color and black and white copying, one and two-color printing, folding, drilling, cutting, envelopes, spiral bound books, and much more. Other services include state park maps, brochures, posters and newsletters. Printed material is produced for any nonprofit organization and federal, state, or local government agency, including universities and K-12 schools. This team employs persons at Columbia Correctional Institution.



INDUSTRIES

Durable Medical Equipment Refurbishing

BCE Durable Medical Equipment (DME) Refurbishing prepares power and manual wheelchairs, bath equipment, and other miscellaneous mobility equipment for sale to customers. Most items are received as donations. Collected equipment is assessed, sanitized, and repaired to like-new condition. The sale of BCE's refurbished DME is on the www.wisconsinAT4ALL.com website with substantial savings passed on to customers compared to purchasing new. BCE partners with Includa, a Wisconsin based non-profit to help those with mobility challenges obtain equipment. This team hires persons at Redgranite Correctional Institution.

Computer Recycling

Computers and select other electronic products that are obsolete or designed as non-repairable are received from the DOC. These items are de-manufactured down to the salable commodities in each device. The commodities are sold in a bidding process to electronic recyclers. This service occurs at BCE's Industries Distribution Center (IDC) and employs persons from John Burke Correctional Center.

Laundry & Linen Rental Services

BCE Laundry provides laundry services to state agencies and universities. Linen rental services are offered to federal, state and local government agencies and campuses, as well as nonprofit organizations. Laundry services sold to facilities operated by the Departments of Corrections, Health Services, and Veterans Affairs include the picking up of dirty items and the delivery of clean items on a regularly scheduled basis. Items include clothing, bedding and coats for persons in our care, and a facility's rags and mops. This team employs persons at Oshkosh Correctional Institution.

Textiles/Embroidery

BCE Textiles produces items sold to the full range of government and non-profit customers, including K-12 schools. Products include, but are not limited to detention clothing, mattresses and pillows, linens, and towels. This team also provides embroidery and heat transfer enhancements to a wide range of products. This team produced more than 40,000 cloth face masks to help reduce the spread of COVID-19 in step with CDC guidelines. This team employs persons at Green Bay Correctional Institution.

Product Development Center (PDC)

The employees and workers on this team create digital assets for the full BCE product life cycle of design, support, and promote. Design services includes submittal and manufacturing drawings for custom furniture, primarily using Solidworks, and AutoCAD. Support services includes creating digital assets for catalogs, brochures, price lists, and updates to our www.shopbce.com. Workers learn to use sophisticated computer applications such as the Adobe Suite, and NetSuite. This team employs persons at Oakhill Correctional Institution.



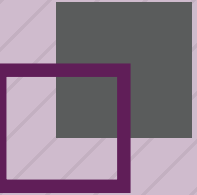
LOGISTICS

Badger State Logistics (BSL)

BSL is team working at a BCE warehouse that serves as the sales and delivery point for a number of consumable products sold to BCE customers. Products include, but are not limited to toilet paper, hand towels, food service supplies, can liners, motor oils, ice melting salt and softener salt. Workers on this team are persons at John Burke Correctional Center.

Industries Distribution Center (IDC)

IDC serves as the central hub for transportation, storage, delivery and installation of BCE products. IDC transports state-wide ranging from 24' straight trucks to 53' tractor-trailers and provides transportation services to other state agencies. IDC's installation team delivers and installs BCE furniture products, repairs furniture on-site and offers project management for large scale installations. Workers on this team are persons at the John Burke Correctional Center.



TRANSITION

The BCE Transition team works to help BCE workers who choose to participate to better prepare themselves for the job search and to connect them with potential employers and community service providers upon return to their families and communities. Transition participants are assisted with preparing a resume and obtaining forms of identification needed to earn employment. Transition team members assess participants by providing job leads near their approved release addresses, information about local social service agencies, and providing short-term supplemental funds for work-related items like tools, special clothing, transportation, and rent.

MAKING A DIFFERENCE

" They get to **LEARN** and **TRAIN** on equipment, but we are also **TEACHING** life **SKILLS**. "



TERRY FERSTL
BCE SUPERINTENDENT

" BCE has allowed me to **EARN** some **SKILLS** to help me go back out into the **WORK** field and be an **ASSET** to any employer. "



FORMER BCE WORKER

" Because of the **NUMBER** of people that are incarcerated in the United States, it's a pool of **PEOPLE** that **SMART EMPLOYERS** can't ignore. "



TOM HARVEY, FORMER
PRODUCT DEVELOPMENT
SPECIALIST

" A lot of guys are honestly just like me, with a **GREAT WORK ETHIC** and have a **PLAN**...and just need a **CHANCE** because once we are out...we don't want to go back. "



FORMER BCE WORKER

IMPACTING LIVES

The work opportunities BCE provides to persons in our care provide them not only valuable work experience, but practical life skills to use in the community. We place a priority on being a difference maker in the lives of our valued workers.



FORMER BCE WORKERS

3 years after release **88%** are **EMPLOYED**, and **71%** do not return to DOC custody for any reason





Bureau of Correctional Enterprises

Main Office/Showroom
3099 East Washington Ave.
Madison, WI 53708

608.240.5200

shopbce.com